

ay, 12/02/2008 2:16:46 PM
acelle

Process Sheet

Order : CU-DAR001 Dart Helicopters Services

Drawing Name : VERTICAL REFERENCE DOOR INSTALLATION, 204

Job Number : 37385

Estimate Number : 12194

P.O. Number :

This Issue : 12/02/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / /

Type : PURCHASED PARTS

Previous Run :

Written By :

Checked & Approved By :

Comment : Est Rev. A 04.11.09 New Issue KJ/JLM

Part Number : D204711015

Drawing Number : N/A

Project Number : N/A

Drawing Revision : N/A

Material : N/A

Due Date : 28/02/2008

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D204-711-015 CHG001

2.0 PG

PURCHASING



Comment: PURCHASING

Issue P/O: 5686 to Eagle Copters

C208/02/12 ①

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

3.0 D412711041

Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

4643563

4.0 EA2046915204

Instrument Panel, 204



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Instrument Panel, 204

Batch

N/A

5.0 D204711115

Wiring Harness



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

1 D204-711-115 Wiring Harness, 204

Attach serviceable tags

Batch

N/A

Date: Tuesday, 12/02/2008 2:16:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR INSTALLATION, 204

Job Number: 37385

Part Number: D204711015

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D412711101

Replacement Bubble Windo



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

CHH Mar 6/08

EAGLE

Pick:Qty Part Number Description Batch

1 204-030 853-119 LH Co-pilot Door 07-000560.1

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 07-009196

1 EA20469-05 Rubber Strip 06-011664

1 EA20469-06 Aluminum Strip Deleted

1 EA20469-07 Angle w/o 43547

1 EA20469-08 Placard w/o 43547

1 EA20469-10 Rear Rib Assy w/o 43547

1 EA20469-11 Angle w/o 43547

1 EA20469-12 Fwd Rib w/o 43547

1 EA20469-13 Window w/o 43547

1 EA20469-14 Window Retainer w/o 42547

1 EA20469-16 Armrest Assy w/o 43547

1 EA20469-17 Angle w/o 43547

1 EA20469-18 Door Inner Skin w/o 43547

1 FA20469-21 Door Cover Panel w/o 43547

2 EA20469-23 Link w/o 43547

1 EA20469-24 Rod w/o 43547

1 EA20469-25 Arm Assy w/o 43547

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

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Drawing Name: VERTICAL REFERENCE DOOR INSTALLATION, 204

Job Number: 37385

Part Number: D204711015

Job Number:



Seq. #:

Machine Or Operation:

Description :

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt 07-18790

22 AN3-4ABolt 08-001209

24 AN3-7ABolt 07-017476

6 AN960-6L Washer 05-022623 (NAS 1149 FN 616 P)

90 AN960-10L Washer 06-018522 (NAS 1149 FO 332 P)

34 CR3242-4-2 Rivet 08-001645

135MS20426AD3-3 Rivet 07-006985

140MS20426AD4-3 Rivet 05-002460

25 MS20470AD3-3 Rivet 07-007189

90 MS20470AD4-3 Rivet 07-015056

24 MS21042L3 Nut 08-002039

2 MS21042L06 Nut 06-014775

13 MS21069L3 Nut Plate 08-001202

8 MS21069L08 Nut Plate 07-018940

1 MS21071L3 Nut Plate 08-002216

1 MS21071L08 Nut Plate 08-001935

9 MS21075L3 Nut Plate 05-004764

2 MS24677-12 Screw 05-011931

6 MS27039-1-09 Screw 07-014232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install CA20409-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0 QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Date: Tuesday, 12/02/2008 2:16:46 PM
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR INSTALLATION, 204

Job Number: 37385

Part Number: D204711015

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-711-015

Location: _____

PPP Rev: _____

*Not required - Door
Installed on A/c by Eagle*

AB

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Good 03/10

Job Completion



Eagle Copters Maintenance Ltd

WORK REPORT

Work Order Number: 43563

V/Door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 DOOR

Squawk: 1.1

Discrepancy:

Modify Door to Vertical Reference Door

Resolution:

Modified Door to Vertical Reference Door as per STC No. SH92-30 on S/O 07-003317.

1.1 Work Done By: Jake Bergh

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81

Signature: Colin Gould on 3/3/2008

Parts:

Part Number	Description	Lot Number	Condition	Qty
204-030-853-037A	SKIN ASSY	LT-07-010253	New	1
BELL212-L	BUBBLE WINDOW ILO EA20469-03 and D412-711-101	LT-07-009196	New	1

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-119		DOOR	Modify

Squawk: 1.2

Discrepancy:

Paint door as required

Resolution:

Door painted as required

1.2 Work Done By: Colin Gould

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

EAGLE COPTERS MAINTENANCE LTD.

823 McTAVISH ROAD N.E., CALGARY, ALBERTA T2E 7G9

D.O.T. APPROVAL No. **6-81**

Nomenclature Door, Copilot
Manufacturer BHT Type/Model 204
Part No. 204-030-853-119 Serial No. w/k
Total time: w/k Work Order 43563
T.S.O. w/k Overhaul ☐ NEW ☐
Inspected ☐ Tested ☐ Repair ☐ Modification ☒ Removal ☐
Previous Certification LT 07-000560.1

The maintenance described has been performed in accordance with the applicable standards of airworthiness.

Feb 28/08

DATE

NAME OR AUTHORIZED INSPECTOR

LIC. No. / STAMP

Details of outstanding work and other information on reverse.

MAINTENANCE RELEASE**REMARKS**

(Details of work performed/reason for removal)

Modified per STC # SH92-30

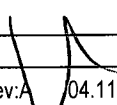
(Additional work to be performed upon installation)

INSTALLED ON.....DATE.....

MAINTENANCE RELEASE

Date: Tuesday, 12/02/2008 2:16:46 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	VERTICAL REFERENCE DOOR INSTALLATION, 204	
Job Number :	37385	Part Number :	D204711015	
Estimate Number :	12194	Drawing Number :	N/A	
P.O. Number :		Project Number :	N/A	
This Issue :	12/02/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	N/A	
First Issue :	/ /	Type :	PURCHASED PARTS	
Previous Run :		Material :	N/A	
Written By :	Due Date :		28/02/2008	Qty: 1 Um: Each
Checked & Approved By :				
Comment :	Est Rev:A 04.11.09 New issue KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D204-711-015 CHG001

2.0

PG

PURCHASING

**Comment:** PURCHASINGIssue P/O: 5684 to Eagle CoptersC208/02/12 ①

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

3.0

D412711041

Vertical Ref. Door Assy

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0

EA2046915204

Instrument Panel, 204

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Instrument Panel, 204

Batch _____

5.0

D204711115

Wiring Harness

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D204-711-115 Wiring Harness, 204

Attach serviceable tags

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Job Number: 37385

Part Number: D204711015

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Machine Or Operation:

Description :

Pick:

Qty Part Number Description Batch

14 AN3-3ABolt _____

22 AN3-4ABolt _____

24 AN3-7ABolt _____

6 AN960-6L Washer _____

90 AN960-10L Washer _____

34 CR3242-4-2 Rivet _____

135MS20426AD3-3 Rivet _____

140MS20426AD4-3 Rivet _____

25 MS20470AD3-3 Rivet _____

90 MS20470AD4-3 Rivet _____

24 MS21042L3 Nut _____

2 MS21042L06 Nut _____

13 MS21069L3 Nut Plate _____

8 MS21069L08 Nut Plate _____

1 MS21071L3 Nut Plate _____

1 MS21071L08 Nut Plate _____

9 MS21075L3 Nut Plate _____

2 MS24677-12 Screw _____

6 MS27039-1-09 Screw _____

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8.0

QC4

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Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

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9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

QC4

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Comment: INSPECT 100% KITS FOR COMPLETENESS

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Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-711-015

Location: _____

PPP Rev: _____

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

